

5/28

DART AEROSPACE LTD.	Work Order :	23786.
Description: 206 Saddle, Inboard, Left Side	Part Number:	D2666-1
Drawing: D2666 Rev. B	Qty:	4

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order Dwg. not required 02/09/16 RF	JH	05.07.08	4
2	STORES	Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 6.0 Grain Along Long 6.0 Length (Q6101-001) RF 02/09/16 Batch No: B20981	JM	05/07/10	4
3	HAAS	Program part number and batch number.	JM	05/07/10	4
4	QC	Inspect part number and batch number are programmed correctly.	JP	05/07/10	4
5	HAAS	Fixturing W/O No. 23786 Fixturing Inspection last completed 05/07/11 by JM	JM	05/07/11	4
6	HAAS	Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet	JM	05/07/11	4
7	HAAS	Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet	JM	05/07/11	4
8	HAAS	Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet	JM	05/07/11	4
9	LAGUN	Machine Keyway and inspect per attached dimension sheet	JM	05/07/11	4
10	METAL	Deburr	JM	05/07/11	4
11	QC	Inspect Level 1	JM	05/07/11	4
12	QC	Inspect Level 8	JP	05/07/11	4
13	METAL	Acid etch and Alodine as per QSI 005 4.1	JM	05/07/11	4
14	FINISHING	Powder Coat High Gloss White (4.3.5.1) per Dart QSI 005 4.3	JM	05/07/11	4
15	QC	Inspect Level 3	JM	05/07/11	4
16	STORES	Pack in foam, identify and stock.	DL	05/07/11	4
17	EXPEDITING	Close Work Order 65-96 Job Cost / Part 65.41	JH	05/07/25	4

Rev	Date	Change	Created By	Approved
A	97.07.24	New Issue		
B	98.09.08	Inspection levels, added powder coat	KS	
C	00.11.01	Removed P/O for Powder Coat – in house process	EC	AS 02.04.25

RELEASED

02/04/25

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: <u>J.P.</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
<u>0507.11</u>	3	<u>Object was off</u>	<u>J.P.</u> <u>was off</u>	<u>give keen,</u> <u>&amp;</u> <u>replace</u>	<u>and</u> <u>0507.11</u>	<u>J.P.</u> <u>0507.11</u>	<u>J.P.</u> <u>0507.11</u>	<u>J.P.</u> <u>0507.11</u>

Part No: D2666-1PAR #: J.P.

Fault Category: \_\_\_\_\_

NCR: Yes  NoDQA: J.A.Date: 05.07.11

NOTE: Date &amp; initial all entries

QA: N/C Closed: \_\_\_\_\_

Date: \_\_\_\_\_

DART AEROSPACE LTD	Work Order:	23786
Description: 206 Saddle, Inboard, Left side	Part Number:	D2666-1
Inspection Dwg: D2666 Rev. B		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.126	0.128	0.136	0.136		
B	0.100	0.140		0.129	0.127	0.124	0.124		
C	0.100	0.140		0.108	0.114	0.112	0.112		
D	0.210	0.230		0.220	0.220	0.220	0.221		
E	1.245	1.255		1.249	1.250	1.250	1.249		
F	1.245	1.255		1.249	1.250	1.250	1.249		
G	5.990	6.010		6.002	6.003	6.003	6.003		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.674	1.684		1.678	1.679	1.678	1.678		
J	2.495	2.505		2.497	2.500	2.498	2.499		
K	0.257	0.262	DT8683	—	—	—	—		
L	0.312	0.317	DT8686	—	—	—	—		
M	0.235	0.240		0.237	0.237	0.238	0.237		
N	0.100	0.140		0.117	0.116	0.116	0.117		
O	0.540	0.560		0.550	0.549	0.548	0.549		
P	0.490	0.510		0.501	0.505	0.502	0.502		
Q	3.609	3.619		3.612	3.611	3.612	3.612		
R	2.470	2.510		2.496	2.497	2.495	2.496		
S	0.240	0.270		0.250	0.252	0.251	0.251		
T	0.100	0.180		0.138	0.142	0.140	0.138		
U	0.313	0.318	DT8686	—	—	—	—		
V	1.125	1.145		1.133	1.132	1.134	1.134		
W	1.565	1.585	DT8695 A/B	—	—	—	—		
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>DMF</i>
Date:	05/07/11

Audited by:	<i>EN</i>
Date:	05/07/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF <i>RF</i>	<i>RF</i>

## Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jul 08, 2005  
01:32 pm

Work Order No : 0023786  
 Project Name : D2666-1  
 Project For : WK528  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D2666-1  
 Description : Saddle, LH, Fwd,Aft, In  
 Manufactured : Yes  
 Amount Req'd : 4  
 Amount Done : 0  
 Start Date : 07-08-05  
 Est Finish Date : 07-23-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Mark Up : 0.000%  
 Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00